

7075-T6 1.750x4.500

Work Order ID 94686

December-19-12 2:52:04 PM

94686

Page 1

Item ID: 647.9314

847.9314
R94686

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer Bracket

Start Date: 1/17/13

Start Qty: 30.00

30

Cust Item ID:

Required Date: 1/17/13

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: ☒

Date: 12-20-12 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.9300

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT AT 8.25" LONG

13-02-20 30 0

110

0.00

110

Outsource5

Memo

0.00

Outsource process - Machining

ISSUE P/O:

19893

POSSIBLE SUPPLIER: ARCHER PRECISION

Certificate of conformaty required

13/05/15 30

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

29x

SP
138-23

See Pink 13-3030

DQA: duA Date: 13/08/17

QA Closed: duA Date: 13/9/16

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: <u>94686</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>647.9314</u>		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>13-3029</u>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Part has marking in Bottom surface	DAS 16	Scrap + Dest.	DAS 27 9-89	DAS 16 9-89	DAS 16 9-89
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input checked="" type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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94686

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N900040100

Setup Start *NS1*

Stop *NS2*

30

30

Reference:

Run Start *NR1*

Stop ***NR2***

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

117

DAS
27
9-89

0.00

OC

Memo

Quality Control

B. 8. 26

09
Coun

0.00

118

0.00

HandFinish

Memo

Hand Finishing

REMOVE ALL PART MARKINGS

NBA

0.00

120

0.00

Outsource4

Memo

Outsource process - Anodize

HARD ANODIZE 1AW MIL-A-8625 TYPE 3
COLOUR BLACK

P10. 21136

CA 13/08/30 29

Work Order ID 94686

94686

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Item ID: 647.9314 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer Bracket
 Start Date: 1/17/13 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 1/17/13 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***	0.00 0.00							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	N/A		DAS 27 9-89				
150 *150* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo PRIME AS PER DWG NOTE #2	0.00 0.00							

73/9/6 (28)

CY 13/05/13

ATG

Work Order ID 94686

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Item ID: 647.9314 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer Bracket
 Start Date: 1/17/13 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 1/17/13 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ DAS Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC14 Inspect Spray Paint 6 Memo	0.00 9-89 0.00 1396				29 Can			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST416</u> Memo	0.00 0.00				29x		13-09-6	
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***	0.00 0.00							

Work Order ID 94686***94686***

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Item ID: 647.9314 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Retainer Bracket
Start Date: 1/17/13 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 1/17/13 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

13/9/9 JJ

RB-09-9

Picklist Print

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Page 1

Work Order ID: 94686
 Parent Item: 647.9314
 Parent Item Name: Retainer Bracket

Start Date: 1/17/13

Required Date: 1/17/13

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 12-11-19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.9314P Retainer Bracket		Purchased	No				Each	0.0000		30			
M7075T6B1.750X04.500 7075-T6 BAR 1.750" X 4.500"		Purchased	No				f	12.0400		21.210	21.789474		

Location

MAT049

124030

Loc Qty

12.04

12.04

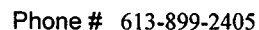
Loc Code

124633

21.210

21.210

1/13/9/5 (24)
 13-02-20



Date	Invoice #
8/19/2013	658

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
19893	8/19/2013	Federal Express	Archer	

Qty	Item Code	Description
29 1	Sales Sales	647.9314P 647.9314P - Scraped HST (ON) on sales 5813-8-23



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

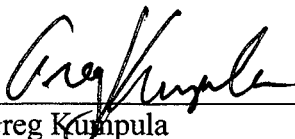
Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
19893	647.9614	29

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 19893 issued by Dart Aerospace Inc.



Greg Kumpula

Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6



Non Conformance Repot

Customer: DART AEROSPACE
Job/ PO# 19893
Part Number: 647.9614
Description: BRACKET
QTY: 30

Reject QTY: 1
Customer Supplied Material: Yes/No
Pictures Attached: Yes/ No

Work Order #: _____
Date: 19 AUG 13
Is the Part Identified: Yes/No

DESCRIPTION OF NONCONFORMANCE

Item	Qty	
#1	1	BOTTOM SURFACE GOUGED.

DISPOSITION PROPOSAL

Item Ref.	
#1	DOES NOT MEET REQUIRED SURFACE FINISH.

CAUSE OF NONCONFORMANCE

Item Ref.	
#1	IMPROPER CLAMPING PRESSURE FOR TOOL FEED

CORRECTIVE ACTION

Item Ref.	
#1	REDUCED TOOL FEED.

CUSTOMER DISPOSITION

Item Ref.	

Inspector/ QA: GREG KUMPULA

Date: 19 AUG 13 NCR# _____

By: _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19893

Purchase Order Date 5/15/2013

PO Print Date 5/15/2013

Page Number 1 of 2

Order From :

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

IC-GLO001

Contact Name

Vendor Phone

613 899 2405

Vendor Fax

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270

HAWKESBURY

CANADA

OTTAWA

ON K6A 1K7

FAKED
6936516

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price
1	647.9312P ✓	Bracket	6/14/2013 Yes	8.00 Each	Day & Ross coll	\$190.0000
2	647.9613P ✓	RH Aft Wiper D	6/14/2013 Yes	5.00 Each	Day & Ross coll	\$340.0000
3	647.9314P	Retainer Bracket	6/14/2013 Yes	30.00 Each	Day & Ross coll	\$252.5690
4	647.9315P	Receptacle Bracket	6/14/2013 Yes	30.00 Each	Day & Ross coll	\$289.5426

SP13-6

SP13-6-2

Recu 29 SP13-8-2

No substitution or deviation with consent.

Certificate of Conformity or Mat Certification required **YES**

Change Nbr: 1

Change Date: 5/15/2013



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62607

Date: 06-Sep-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

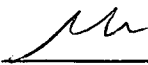
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 2 PCS D2000-047 30 PCS BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 29 PCS 647.9314 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377 J TYPE I CLASS N Job: 20130555 Rev: Line:		
<p style="text-align: center;">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p style="text-align: center;">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : <u>6/9/13</u></p> <p>CERTIFIED SIGNATURE : <u></u></p> <p>RECEIVER SIGNATURE : _____</p>			